

101207

JUNE 1

A06

Item ID: D350-591-311 - 2

Revision ID:

Item Name: Heli-Access-Step, Long FH

Start Date: 5/07/13 Start Qty: 10.00

Required Date: 5/31/13 Req'd Qty: 10.00

Reference:

Accept

N9000040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

QC:

Date: 130507 Tooling:

Date:

SPC (Y/N):

Date:

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3272

Rev B

100

100

DC

Document Control

DOCUMENT CONTROL

0.00

Memo

0.00

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

N/A

110

110

Large Fab

Large Fab

Large Fab

0.00

Memo

0.00

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/RAluminum Rod

3-Grind End Plate flush

130514
A2
130514

Item ID: D350-591-311

Revision ID:

Item Name: Heli-Access-Step, Long LH

Start Date: 5/07/13 Start Qty: 10.00

Required Date: 5/31/13 Req'd Qty: 10.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject Reject Insp.
Qty Qty Number Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

10 0 13-05-15

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

BS IS

10

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

10 0 Ak. 13-05-15

Item ID: D350-594-311

Revision ID:

Item Name: Heli-Access-Step, Long LH

Start Date: 5/07/13 Start Qty: 10.00

Required Date: 5/31/13 Req'd Qty: 10.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Reject
Qty Qty Reject
Number Insp.
Stamp

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

Quality Control

10

φ

DAS
19
2-09

13.05.16

180

0.00

180

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/RAluminum Rod 125127

6-Grind End Plate flush

7-Install last rivet as per Dwg.

10

φ

13.05.16

13.05.21

Item ID: D350-591-311

Revision ID:

Item Name: Heli-Access-Step, Long LH

Start Date: 5/07/13 Start Qty: 10.00

Required Date: 5/31/13 Req'd Qty: 10.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

190

QC10- Inspect visual per QSI004- ground welds

0.00

190

QC

Memo

0.00

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

210

Chemical Conversion Coat per QSI005 4.1

0.00

210

HandFinish

Memo

0.00

Hand Finishing

27
09
2-83

BS-21

27
09
2-83

BS21

Ac 13.05.21

1 φ

101267.

Item ID: 1350-591-311

Revision ID:

Item Name: Heli-Access-Step, Long LH

Start Date: 5/07/13 Start Qty: 10.00

Required Date: 5/31/13 Req'd Qty: 10.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

220

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

0.00

0.00

1X φ M.F 13/05/21

230

Wing Walk as per dwg QSI005 4.4 Batch 125314.

0.00

230

HandFinish

Hand Finishing

Memo

0.00

1 φ BL 13-5-21.

240

QC3- Inspect Part Finish

0.00

240

QC

Quality Control

Memo

0.00

DAS
27
0.00

13.5-22

1

Item ID: D350-591-311

Revision ID:

Item Name: Heli-Access-Step, Long LH

Start Date: 5/07/13 Start Qty: 10.00

Required Date: 5/31/13 Req'd Qty: 10.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

Pick Kit

0.00

250

Packaging

Packaging

Memo

0.00

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Quality Control

Memo

0.00

270

Packaging

0.00

270

Packaging

Packaging

Memo

0.00

Identify and pack for shipping as per PPPD350-591-311
Location: _____

A-

Ship as

is no kit.

customer requires

D3272-001

see w/o

#101891

Item ID: 1350-591-311

Revision ID:

Item Name: Heli-Access-Step, Long LH

Start Date: 5/07/13 Start Qty: 10.00

Required Date: 5/31/13 Req'd Qty: 10.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

13/5/22 DJ

MF
13-5-22

17

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

D350-591-311

Start Date: 5/07/13

Required Date: 5/31/13

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3272-1 JLM

IPP C returned to CHG001 for Eurocopter, ref NCR08-082 L1. Verified

by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1		Manufactured	No			110	Each	0.0000	1	10			
D3272-1						BIC1154			**	10		13.05.07	
Step													
D3067-1		Manufactured	No			110	Each	161.0000	1	10			
D3067-1									**			13.05.13	
End Plate													

Location

Loc Qty

Loc Code

WA	78	
95515	5	
98655	73	
WA003	83	
67582	2	
68214	1	
78608	4	
79607	1	
83855	1	
90178	1	
90486	3	
95170	64	
95930	6	

9

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long L.H.

D3219-1

Manufactured No

110 Each

D3219-1

Plate

Start Date: 5-07-13

Required Date: 5-31-13

Start Qty: 10.00

Required Qty: 10.00

92.0000 2 20

**

13.05.13

Location

Loc Qty

WA003

92

73410

12

77674

6

89967

2

96264

72

Loc Code

D3066-1

Manufactured No

180 Each

D3066-1

Spacer

61.0000 2 20

**

13.05.16

Location

Loc Qty

WA003

61

95963

4

99840

57

180 Each

Loc Code

MS20600-AD4W4

Purchased No

MS20600-AD4W4

Rivets

1,062.000 16 160

**

ms20600 -> 89

13.05.16

Location

Loc Qty

ST311

1062

123900

350

125406

712

180 Each

Loc Code

D3065-041

Manufactured No

D3065-041

Step Leg Assembly Hi

17.0000 1 10

**

B99652 -> 4

13.05.16

Location

Loc Qty

WA003

17

79336

1

97928

16

Loc Code

May-07-13 11:14:55 AM

Shop Packet Print

Page 2

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

D3067-1

D3067-1

End Plate

Manufactured No

180 Each

Start Date: 5/07/13

Start Qty: 10.00

Required Date: 5/31/13

Required Qty: 10.00

161.0000 1 10

**

13.05.21

Location

Loc Qty

WA	78
95515	5
98655	73
WA003	83
67582	2
68214	1
78608	4
79607	1
83855	1
90178	1
90486	3
<u>95170</u>	64
95930	6

Each

Loc Code

405.0000 2 20

**

AN3-35A

AN3-35A

Bolt

Purchased No

Location

Loc Qty

FG	10
122800	10
ST352	395
125211	395

Loc Code

May-07-13 11:14:56 AM

Shop Packet Print

Page 3

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

D350-591-311

D3235-1

Manufactured No

250 Each

D3235-1

Mounting Lug

Location

Loc Qty

ST470

251

90002

2

92286

1

96415

28

99256

100

99406

120

D3278-041

Manufactured No

250 Each

D3278-041

Support Assembly

Location

Loc Qty

ST470

64

90706

1

97909

23

99297

40

AN960JD416

NAS1149D0463J Purchased No

250 Each

AN960JD416

Washer

WMC 5-5-21

AN960JD516

NAS1149D0563J Purchased No

250 Each

AN960JD516

Washer

Location

Loc Qty

ST504

2

1069059

2

Start Date: 5-07-13

Required Date: 5-31-13

Start Qty: 10.00

Required Qty: 10.00

251.0000 2 20

**

Loc Code

64.0000 1 10

**

Loc Code

0.0000 16 160

**

2.0000 4 40

**

Loc Code

May-07-13 11:14:56 AM

Shop Packet Print

Page 4

Work order 42

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long L.H.

17012607

D350-591-311

AN5-36A

AN5-36A

Bolt

Purchased

No

250

Each

Start Date: 5/07/13

Start Qty: 10.00

Required Date: 5/31/13

Required Qty: 10.00

127.0000 2 20

**

Location

Loc Qty

Loc Code

ST338

1

123525

1

ST517

126

125388

126

Manufactured

No

250

Each

244.0000 2 20

**

D2618

D2618

Bushing

Location

Loc Qty

Loc Code

ST013

244

89275

1

97780

124

99529

119

Manufactured

No

250

Each

420.0000 4 40

**

D2230-3

D2230-3

Lug

Location

Loc Qty

Loc Code

EG

4

89045

4

ST469

416

89782

19

90514

1

94957

4

96117

7

97815

373

97903

4

98912

8

May-07-13 11:14:56 AM

Shop Packet Print

Page 5

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

D350-591-311

Start Date: 5-07-13

Required Date: 5-31-13

Start Qty: 10.00

Required Qty: 10.00

D2856-400

Manufactured No

250

1

266.9839

1.2

12

D2856-400

Abrasion Strip

**

Location

Loc Qty

Loc Code

ST408	153.45	
99378	153.45	
ST410	38.5	
95159	38.5	
ST415	75.0339	
63735	0.6696	
68076	0.3149	
71164	8.46	
81875	6.398	
86905	0.9569	
89352	24.6745	
90764	33.56	

N A

mk

13-5-21

250

Each

4,195.000

2

20

**

*** cut (2) at 7.20" (D2856-400-720) ***

MS21042L3

MS21042L3

Nut

Purchased

No

Location

Loc Qty

Loc Code

FP001	3	
122141	3	
GA	18	
122452	18	
ST314	268	
117885	32	
119017	55	
119075	138	
123265	43	
ST506	3906	
123900	974	
124291	2932	

May-07-13 11:14:56 AM

Shop Packet Print

Work Order 126 1011

Parent Item: 10350-591-311

Parent Item Name: Heli-Access-Step, Long LH

101267

10350-591-311

Start Date: 5-07-13

Required Date: 5-31-13

Start Qty: 10.00

Required Qty: 10.00

AN4-13A

Purchased

No

250

Each

AN4-13A

Bolt

863.0000

8

80

**

Location

Loc Qty

EG

20

122808

20

Return2012

8

122416

8

ST313

812

125388

812

ST514

23

122993

13

123900

10

Each

MS21042L5

Purchased

No

250

Each

MS21042L5

Nut

149.0000

2

20

**

Location

Loc Qty

ST506

149

123900

149

250

Each

MS21042L4

Purchased

No

MS21042L4

Nut

Loc Code

485.0000

8

80

**

Location

Loc Qty

FP001

50

122452

38

8182

12

ST518

435

124231

435

250

Each

AN960JD10

NAS1149D0363J

Purchased

No

AN960JD10

Washer

0.0000

4

40

**

May-07-13 11:14:56 AM

Shop Packet Print

DART

DESIGN 97	DRAWN BY B	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED H	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.18

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

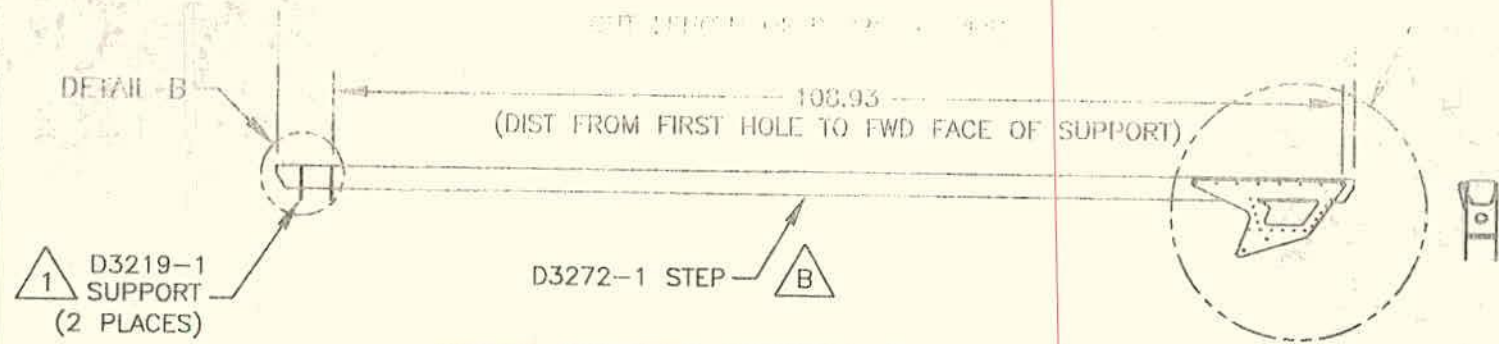
101267
130501

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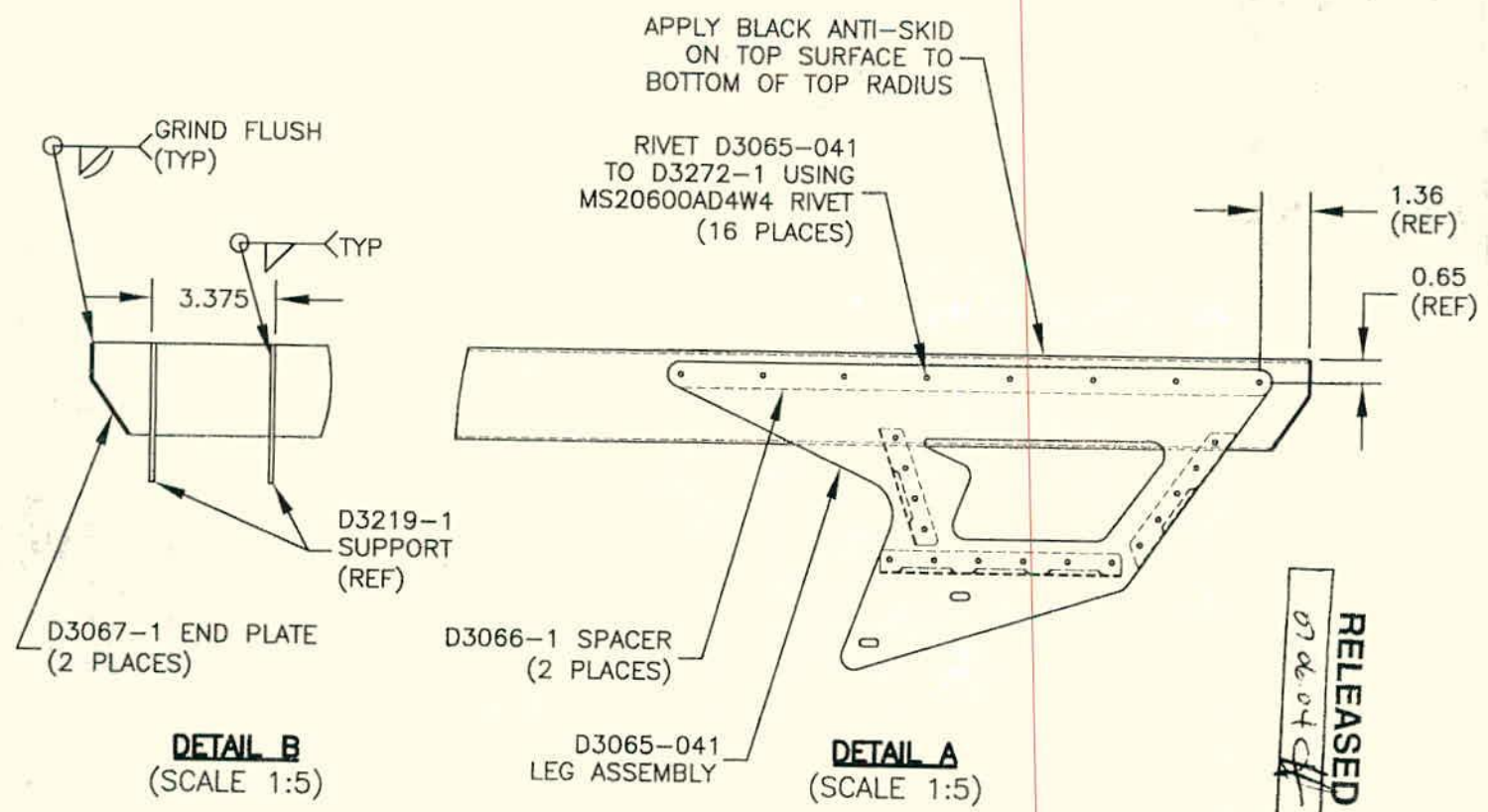
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101267

DART



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



RELEASED
07.05.18

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>Le</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 07.05.18	DRAWING NO. D3272	REV. B
	TITLE STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
		SCALE 1:20

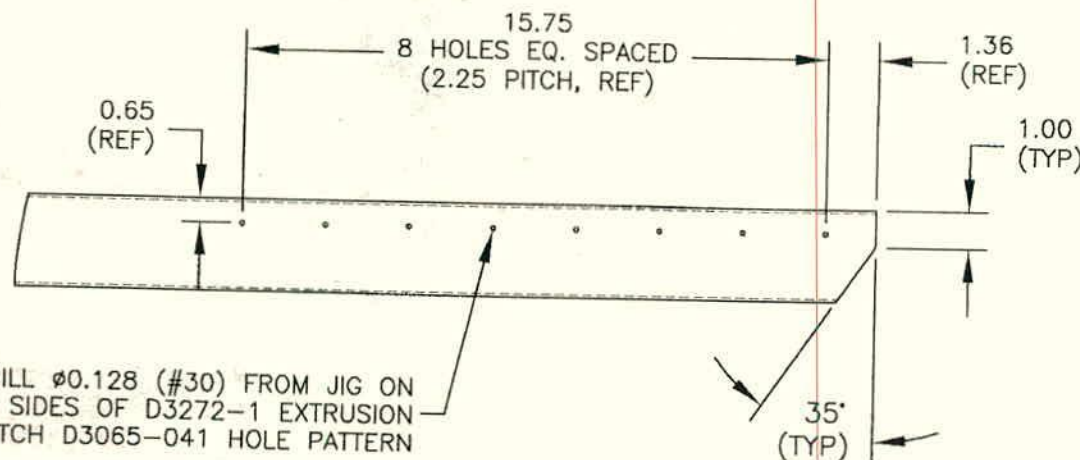
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DART

DESIGN	q	DRAWN BY	J	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	CE	APPROVED	H	DRAWING NO.	REV. B
DATE	07.05.18			D3272	SHEET 3 OF 3
				TITLE	SCALE
				STEP ASSEMBLY, HI LONG	1:20



B **D3272-1 STEP**
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON
BOTH SIDES OF D3272-1 EXTRUSION
TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

RELEASED
07.06.04

